

Date: Monday, 11/08/2008 2:45:50 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WINDOW
Job Number : 41134	
Estimate Number : 10063	
P.O. Number :	Part Number : D2958
This Issue : 11/08/2008 S.O. No. :	Drawing Number : D2958 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : THERMOFORMING	Drawing Revision : E
Previous Run : 36858	Material :
Written By :	Due Date : 29/08/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JLD 088.11</u>	
Comment : E 01.09.25 Done by outside contract SM	
Est 07.06.26 Thermoform in house DL	
est 07.09.28 rev E dwg EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
-----	-------------	------------------------



Comment: Qty.: 2.7090 sf(s)/Unit Total : 54.1800 sf(s)
 1/8" Polycast II Sheet

Batch # 108344 HB 8-8-20



2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



E
E

HB 8-8-20



Comment: FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 8-8-20



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/08/20 (22)

5.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg D2958 and Folio FTA005

Dwg. Rev. E
 Folio Rev. B

OK

08.08.27.

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/08/2008 2:45:50 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 41134

Part Number: D2958

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(PK) →

x22

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformances.

DL 08.08.27

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08.09.02

8.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

- wrap in protective film.
- Water sand and buff to remove scratches as required

08/09/02
BP 08/08 X

(PK)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.09.02 (19)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

attach too
w/o # 41132

SAD 08/11/20

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/24

Job Completion



MF 08-11-21

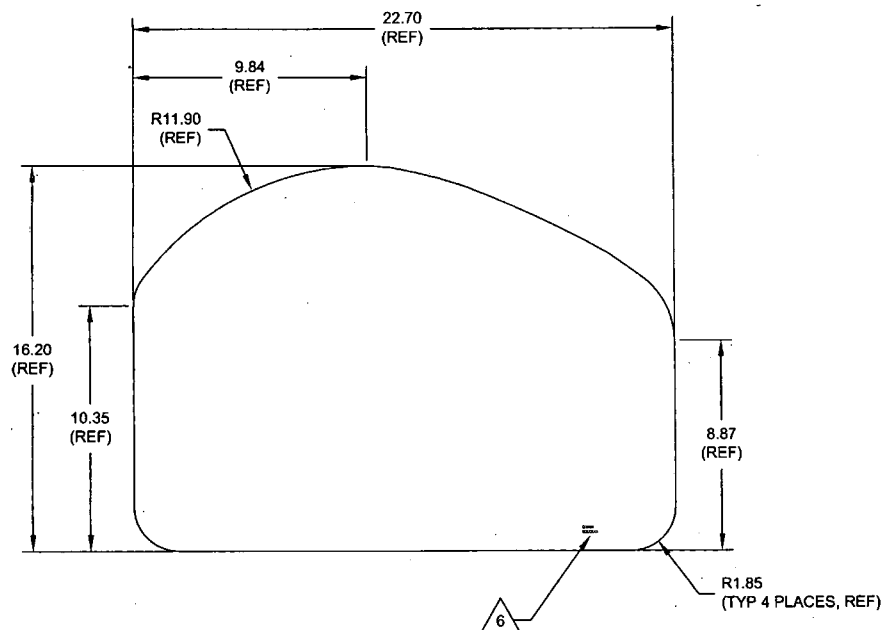
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08-09-02	8.0	wrap windows in plastic film. perm. change	[Signature]	08.11.24		[Signature] 08-09-02	[Signature] 08-09-02	

Part No: D2958 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR: 41134		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/02	# 7.0	During Heroniforming it was found that two windows have large chips on the outside.	[Signature]	Scrap and destroy no replace Qty ③	[Signature] 08/09/02	[Signature]	[Signature]	[Signature]
		EC Blow out from water jet, were not seen during inspection (second check)	[Signature]			[Signature] 08-09-02	[Signature]	[Signature]

NOTE: Date & initial all entries



D2958 FLAT PATTERN

RELEASED
07.09.22

D2958 WINDOW:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2958" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.58 +/- 0.35 LBS
- 8) MOLD PER DART TOOL DT8567

DESIGN	DATE	07.07.06
DRAWN	DC	07.07.06
CHECKED	SSH	06.04.13
MFG. APPR.	CP	01.05.30
APPROVED	CP	00.02.23
DE APPR.	CP	00.01.20
DATE	07.07.06	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWING NO. D2958 TITLE WINDOW SCALE 1:5 REV. E SHEET 1 OF 1		
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 WORK ORDER
 NO 14139

